

Work Order ID 72354

Friday, July 22, 2011 2:50:36 PM



Page 1

Item ID: D206-628-021

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step LH

Start Date: 7/22/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 2.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date: 11/07/22 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
N/A	Rev N/A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels as per PPP D206-628-021 CHG 002

CHG 003

8 11/08/14

JB for BG 11-8-12

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

JB 11/08/10

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

8 11/08/14

x2
H4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D206-628-021

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Item Name: Heli-Access-Step LH

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Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D206-628-021 □ Location: 71 □ PPP Rev: 4

11/14 sf [Signature]

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/15 [Signature]
MF
11-09-15

72358

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 72354

Parent Item: D206-628-021

Parent Item Name: Heli-Access-Step LH

Start Date: 7/22/2011

Required Date: 7/29/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:D as per ECN 766 JLM
IPP Rev:E as per ecn 1118 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-14A Bolt		Purchased	No			120	Each	143.0000	4	8			
-----------------	--	-----------	----	--	--	-----	------	----------	---	---	--	--	--

Location Loc Qty Loc Code

ST357 143

117872 143

AN4-15A Bolt		Purchased	No			120	Each	295.0000	8	16			
-----------------	--	-----------	----	--	--	-----	------	----------	---	----	--	--	--

Location Loc Qty Loc Code

ST357 195

117423 195

ST358 100

118112 100

AN960C416 washer	NAS1149C0463 R	Purchased	No			120	Each	0.0000	12	24			
---------------------	-------------------	-----------	----	--	--	-----	------	--------	----	----	--	--	--

D2724-041 206L Step Assembly		Manufactured	No			120	Each	0.0000	1	1			
---------------------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Pro →

11/08/10

W/O: 72354		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D266-628-021 PAR #: 11/843 Fault Category: Production Eng - coordinators NCR: Yes No DQA: CP Date: 11/09/15
 Resolution: Fix w/o + Bom Disposition: Fix w/o + Bom QA: N/C Closed Date: 11/09/15

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/09/15	#100	wrong part being pulled up - R.C. Lack of Attention when typing part in to w/o + Bom	CP 11.09.15	Fix Part. Should be AN960 3D 416 / WAS 1149 D0463J Attach. FIX CHG # ADD copy of Bom for Ref.	11.09.15	11/09/15	CP 11.09.15 051042	11/09/15

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 72354

Parent Item: D206-628-021

Parent Item Name: Heli-Access-Step LH

Start Date: 7/22/2011

Required Date: 7/29/2011

Start Qty: 2.00

Required Qty: 2.00

-D2731-7 Manufactured No

120 Each

67.0000

4

8

✓

Mounting Lug

Location

Loc Qty

Loc Code

ST420

4

71083

4

ST470

63

62929

19

66427

32

69177

12

62929 44
66427 44

D2732-030 Manufactured No

120 Each

6.0000

8

16

✓

Rubber Cushion

Location

Loc Qty

Loc Code

ST402

6

69205

6

120 Each

89.0000

4

8

-D3394-043 Manufactured No

Lug Assembly

Location

Loc Qty

Loc Code

ST420

2

71082

2

ST475

87

62930

12

62976

28

66429

34

69180

13

62930 44
62976 44

11/08/10
C2

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 72354



Parent Item: D206-628-021



Parent Item Name: Heli-Access-Step LH

Start Date: 7/22/2011

Required Date: 7/29/2011

Start Qty: 2.00

Required Qty: 2.00

MS21042L4

Purchased

No

120

Each

3,673.000

12

24

✓



Nut



JB 11/08/10
PQ

Location

Loc Qty

Loc Code

ST300

3673

117441

1426

117601

747

117885

1500

117441

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.1 D206-628-011/-012/-021/-022/-031/-032 REGULAR DART HELI-ACCESS- STEPS™ PARTS LIST

Qty -011	Qty -012	Qty -021	Qty -022	Qty -031	Qty -032	Part Number	Description
X						D206-628-011	206 A/B STEP INSTALLATION LH
	X					D206-628-012	206 A/B STEP INSTALLATION RH
		X				D206-628-021	206 L/L1/L3/L4 STEP INSTALLATION LH
			X			D206-628-022	206 L/L1/L3/L4 STEP INSTALLATION RH
				X		D206-628-031	407 STEP INSTALLATION LH
					X	D206-628-032	407 STEP INSTALLATION RH
1						D2721-041	STEP ASSEMBLY LH
	1					D2721-042	STEP ASSEMBLY RH
		1		1		D2724-041	STEP ASSEMBLY LH
			1		1	D2724-042	STEP ASSEMBLY RH
				4	4	D2731-3	MOUNTING LUG
4	4	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
				4	4	D3394-041	MOUNTING LUG
				4	4	*D3394-1	*MOUNTING LUG
				8	8	*MS35489-93	*GROMMET
4	4	4	4			D3394-043	MOUNTING LUG
4	4	4	4			*D3394-3	*MOUNTING LUG
8	8	8	8			*MS35489-93	*GROMMET
4	4			4	4	AN4-13A	BOLT
4	4	4	4	4	4	AN4-14A	BOLT
4	4	8	8	4	4	AN4-15A	BOLT
12	12	12	12	12	12	NAS1149D0463J	WASHER (AN960JD416)
12	12	12	12	12	12	MS21042L4	NUT (OR MS21042-4)

*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE



REFERENCE ONLY

DESIGN KE
DRAWN BY PH
DART AEROSPACE USA, INC.
PORT HADLOCK, WA

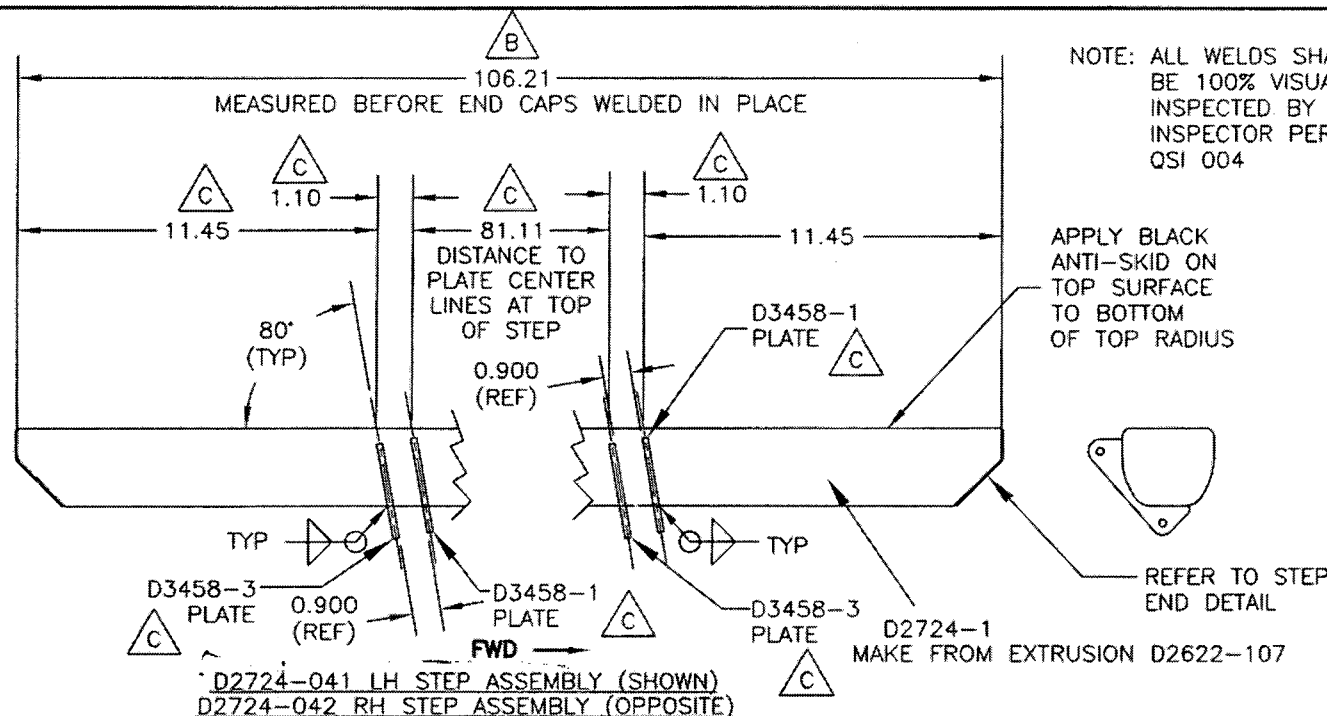
CHECKED
APPROVED
DRAWING NO. D2724
SHEET 1 OF 1

DATE 05.09.19
TITLE 206L/407 STEP ASSEMBLY
SCALE NTS

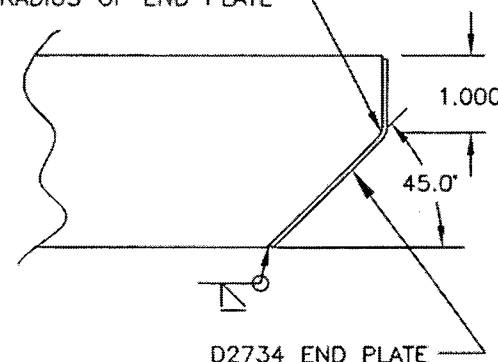
REV. C
REVISED WELD DETAIL
REVISED TOLERANCES
RE-DESIGN, ADD D3458-1/-3

RELEASED
05.11.14

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004



ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Status	Item ID	Rev	Name	Start Date	Quantity Per	UOM	Scrap %	Route Seq ID	Comments	Sort	Stop Date	Date Last Mod	Add Date
✓	AN4-15A		Bolt	1/1/2008	8.0000	Each	0 %	120		0		12/5/2009 6:1...	12/5/2009
✓	NAS1149D0463J		Washer	9/15/2011	12.0000	Each	0 %	120		0		9/15/2011 12:...	9/15/2011
✓	D2724-041		206L Step Assembly	12/5/2009	1.0000	Each	0 %	120		0		12/5/2009 6:2...	12/5/2009
✓	D3394-043		Lug Assembly	12/5/2009	4.0000	Each	0 %	120		0		12/5/2009 6:4...	12/5/2009
✓	D2732-030		Rubber Cushion	12/5/2009	8.0000	Each	0 %	120		0		12/5/2009 8:2...	12/5/2009
✓	AN4-14A		Bolt	1/1/2008	4.0000	Each	0 %	120		0		12/5/2009 6:1...	12/5/2009
✓	D2731-7		Mounting Lug	12/5/2009	4.0000	Each	0 %	120		0		12/5/2009 6:2...	12/5/2009
✓	MS21042L4		Nut	1/1/2008	12.0000	Each	0 %	120		0		12/5/2009 6:1...	12/5/2009